



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
3. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
5. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS		M7200003-00		
.X - .1 [2.5]		DRAWN BY		
.XX - .01 [0.25]		MUSCIA		
.XXX - .005 [0.13]		DATE		
SURFACE ROUGHNESS		4/7/98		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		CHIEF DESIGN ENGINEER		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		D. SHU		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		DATE		
		5/2/98		
		GP LEADER		
		T.M. KUZAY		
		DATE		
		5/4/98		
		PROJECT MGR.		
		DATE		
		APPROVED/RELEASED		
		DATE		
		MATERIAL		
		304 STAINLESS STEEL		
		SCALE 1:1		
		SIZE B		
		DRAWING NUMBER		
		M7-200003-00		
		SHEET 14		